



# Work Order ID 53600

November 9, 2009 1:42:22 PM



Page 1

Item ID: D2989-041 Accept  Setup Start   
 Revision ID: D Stop   
 Item Name: Basket Lid Assembly  
 Start Date: 09/11/2009 Start Qty: 1.00  Cust Item ID:  
 Required Date: 20/11/2009 Req'd Qty: 1.00  Customer:  
 Reference:

Approvals: Process Plan: BP Date: 09-11-09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |                |              |              |               |               |                  |                |
| D2989                          | Rev D                    |                      |                |              |              |               |               |                  |                |

100  Large Fab 0.00

Large Fab

## Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig  
 \*\*\*\*cut cutouts with zip cut as per dwg D3832\*\*\*\*

3- remove from jig and weld lable plate as per dwg D2989  
 A/R ER316 S.S. Rod Batch: M109213

09/11/12 (1x)

110 QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

## Memo

0.00

Quality Control






09 11 13



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Item ID: D2989-041 Accept  Setup Start   
Revision ID: D Stop   
Item Name: Basket Lid Assembly  
Start Date: 09/11/2009 Start Qty: 1.00  Cust Item ID:  
Required Date: 20/11/2009 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

| Sequence ID/<br>Work Center ID   | Operation<br>Description                      | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120  | QC5- Inspect part completeness to step on W/O | 0.00                 |                |              |              |               |               |                  |                |
|  |   |                      |                |              |              | 1             |               |                  |                |
| QC   | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control  |   |                      |                |              |              |               |               |                  |                |

|   |   |      |  |  |  |  |  |  |  |
|---|---|------|--|--|--|--|--|--|--|
| 130   | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel | 0.00 |  |  |  |  |  |  |  |
|  | + PRESSURE WASH                               |      |  |  |  |  |  |  |  |
| Powdercoat  | Memo  | 0.00 |  |  |  |  |  |  |  |
| Powder Coating  | 1- Plug holes prior to powder coating         |      |  |  |  |  |  |  |  |

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

M112148

1ST COAT:  
START TIME: 10:45am  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 11:15am

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:  
START TIME: 11:15am  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 12:45am

=> Del 09/11/16 (X1) Ø

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|                |                     |            |      |       |               |  |
|----------------|---------------------|------------|------|-------|---------------|--|
| Item ID:       | D2989-041           | Accept     |      | Setup | Start         |  |
| Revision ID:   | D                   |            |      |       | Stop          |  |
| Item Name:     | Basket Lid Assembly |            |      |       |               |  |
| Start Date:    | 09/11/2009          | Start Qty: | 1.00 |       | Cust Item ID: |  |
| Required Date: | 20/11/2009          | Req'd Qty: | 1.00 |       | Customer:     |  |
| Reference:     |                     |            |      |       |               |  |

|            |               |       |            |       |     |       |  |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           | Date: | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 131<br>                        | Wing Walk as per dwg QSI005 4.4 Batch <i>m112623</i>  | 0.00                 |                |              |              |               |               |                  |                |
| HandFinish                     | Memo  | 0.00                 |                |              |              | <i>X1</i>     |               |                  |                |
| Hand Finishing                 | Mask lid prior to spray paint black and wing walk as per dwg<br>A/R Spray paint black batch: <i>m112473</i> |                      |                |              |              |               |               |                  |                |
| 140<br>                        | QC3- Inspect Part Finish  | 0.00                 |                |              |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |                |              |              | <i>Q</i>      |               |                  |                |
| Quality Control                |   |                      |                |              |              |               |               |                  |                |
| 141<br>                        | Identify as per dwg & Stock Location: _____   | 0.00                 |                |              |              |               |               |                  |                |
| Packaging                      | Memo <i>RRP 32596</i>   | 0.00                 |                |              |              |               |               |                  |                |
| Packaging                      |   |                      |                |              |              |               |               |                  |                |

*MO 09/11/17*

*PR 09-11-17*

*C9/11/2009*

**Work Order ID 53600**

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Item ID: D2989-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/26

Pl 09-11-25

# Picklist Print

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Page 1

Work Order ID: 53600

Parent Item: D2989-041RevD

Parent Item Name: Basket Lid Assembly



Comments:

Start Date: 09/11/2009

Required Date: 20/11/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick  | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| D2221-1RevH  |                        | Manufactured  | No          |                     |                  | 100             | Each               | 18.0000        | 2.0000  |               |                |        |
|  |                        |               |             |                     |                  |                 |                    |                |  | SAD           | 09-11-19       |        |
| Rib  |                        |               |             |                     |                  |                 |                    |                |   |               |                |        |

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

17

51872

5

53213

12

2x SAD 09/11/11

D2506RevF



Label Plate

Manufactured No

100

Each

9.0000

1.0000



SAD 09-11-19

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

1

44275

1

Main Warehouse

WA

8

52834

8

1x SAD 09/11/11

# Picklist Print

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Work Order ID: 53600



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2512-7RevE<br><br>Rib          |                        | Manufactured  | No          |                     |                  | 100             | Each               | 7.0000         | 1.0000<br>               | SAD           | 09-11-19       |        |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

48666

3

53444

4

D2581RevA1

Manufactured No

100

Each

48.0000

2.0000



Mounting Bracket

SAD

09-11-19

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

46086

2

48428

1

51120

9

Main Warehouse

WA

36

50872

1

51745

35

2x

09/11/11

# Picklist Print

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Work Order ID: 53600



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2989-13RevD                    |                        | Manufactured  | No          |                     |                  | 100             | Each               | 6.0000         | 2.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          | SAD           | 09-11-19       |        |
| Rib                             |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

WA

6

51864

2

53128

4

2x 24 09/11/11

D2989-19RevD

Manufactured

No

100

Each

7.0000

2.0000



SAD 09-11-19

Rib

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

1

44867

1

Main Warehouse

WA

6

51338

2

51874

4

2x 24 09/11/11

# Picklist Print

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Work Order ID: 53600



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3832-3RevA                     |                        | Manufactured  | No          |                     |                  | 100             | Each               | 3.0000         | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Mesh (Lid)                      |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

SAD 09-11-19

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

3

51865

3

D3833-3RevA

Manufactured

No

100

Each

13.0000

2.0000



Mesh (Lid End)

1x SY 09/11/11

SAD 09-11-19

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

13

46308

1

53136

12

2 SY 09/11/11

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Shop Packet Print

Page 4



# Picklist Print

Page 5

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Work Order ID: 53600



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3836-041RevA                   |                        | Manufactured  | No          |                     |                  | 100             | Each               | 3.0000         | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Rib Assembly (Basket Lid, LH)   |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

SAD 09-11-19

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

1

51336

1

Main Warehouse

WA

2

53129

2

1x 09/11/11

D3836-042RevA

Manufactured

No

100

Each

5.0000

1.0000



Rib Assembly (Basket Lid, RH)

SAD 09-11-19

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

3

51337

2

53436

1

Main Warehouse

WA

2

53130

2

53612

1x

09/11/10

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Shop Packet Print

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# Picklist Print

November 9, 2009 1:42:22 PM

Work Order ID: 53600



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D3852-041RevA      Manufactured      No



100      Each      3.0000      1.0000



*SAD 09-11-19*

Rib Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

51333

1

53127

2

100      Each      3.0000      1.0000



*IX 09/11/11*

*SAD 09-11-19*

D3852-042RevA      Manufactured      No



Rib Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

51332

1

53126

2

*IX 09/11/11*

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **53600**  
**BT 09-11-9**

| ITEM | QTY<br>-041 | QTY<br>-043 | P/N       | DESCRIPTION               |
|------|-------------|-------------|-----------|---------------------------|
| 1    | X           |             | D2989-041 | BASKET LID ASSEMBLY       |
| 2    |             | X           | D2989-043 | BASKET LID ASSEMBLY       |
| 3    | 1           |             | D2506     | LABEL PLATE               |
| 4    | 1           |             | D2512-7   | RIB                       |
| 5    | 2           |             | D2581     | MOUNTING BRACKET          |
| 6    |             | 1           | D2989-3   | RIB                       |
| 7    |             | 1           | D2989-4   | RIB                       |
| 8    |             | 2           | D2989-5   | RIB                       |
| 9    | 2           |             | D2989-13  | RIB                       |
| 10   | 2           | 1           | D2989-17  | RIB                       |
| 11   | 2           |             | D2989-19  | RIB                       |
| 12   |             | 2           | D3182-1   | HINGE                     |
| 13   |             | 2           | D3442-3   | SHIM                      |
| 14   |             | 1           | D3827-041 | RIB ASSY (INBOARD)        |
| 15   | 1           |             | D3832-3   | MESH, BASKET LID          |
| 16   |             | 1           | D3832-5   | MESH, BASKET LID          |
| 17   | 2           |             | D3833-3   | MESH, LID END             |
| 18   |             | 2           | D3833-5   | MESH, LID END             |
| 19   | 1           |             | D3836-041 | RIB ASSY (BASKET LID, LH) |
| 20   | 1           |             | D3836-042 | RIB ASSY (BASKET LID, RH) |
| 21   |             | 1           | D3838-041 | RIB ASSY (BASKET LID, LH) |
| 22   |             | 1           | D3838-042 | RIB ASSY (BASKET LID, RH) |
| 23   | 1           |             | D3852-041 | RIB ASSEMBLY              |
| 24   | 1           |             | D3852-042 | RIB ASSEMBLY              |

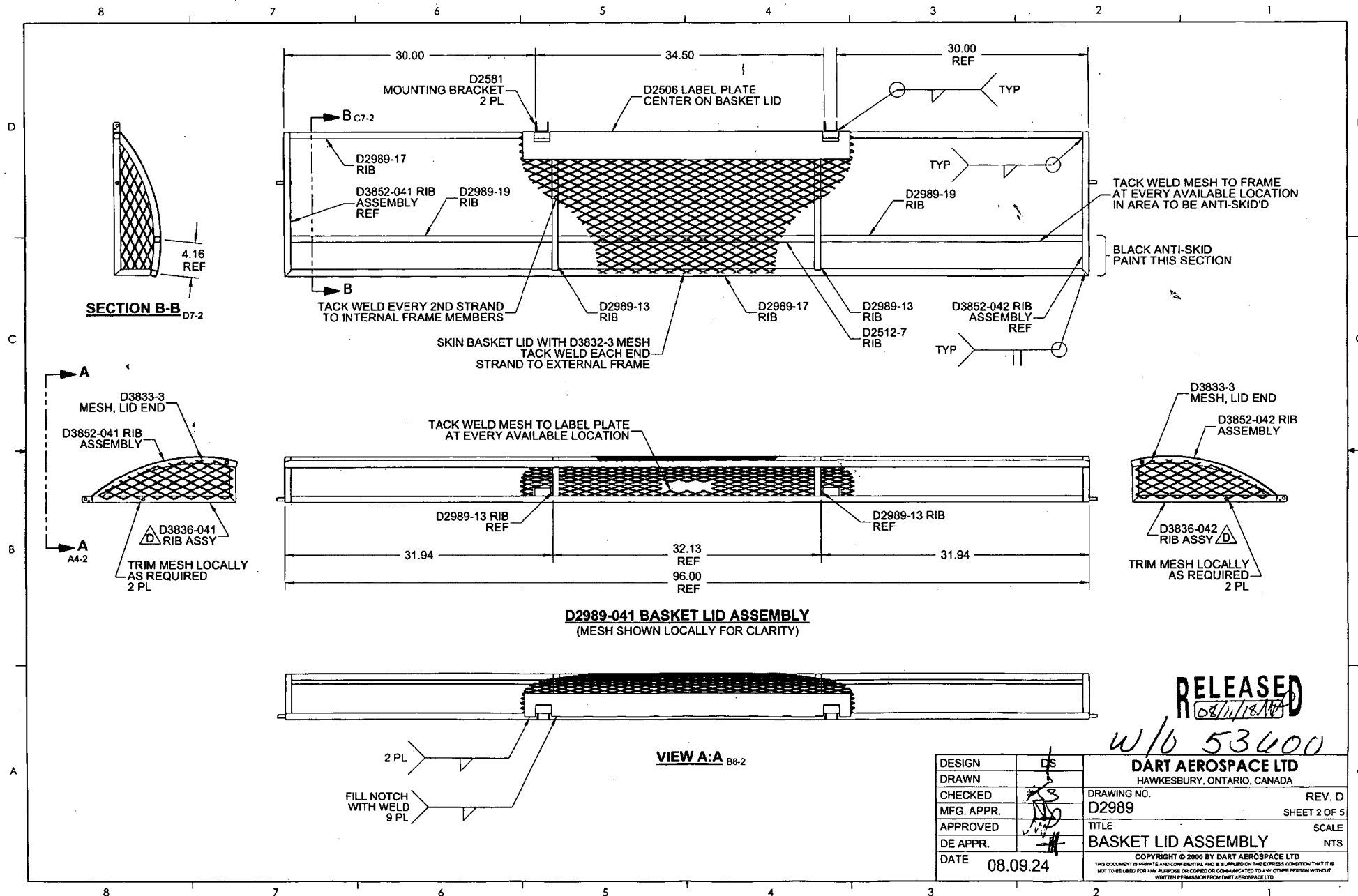
**RELEASED**  
08/11/18

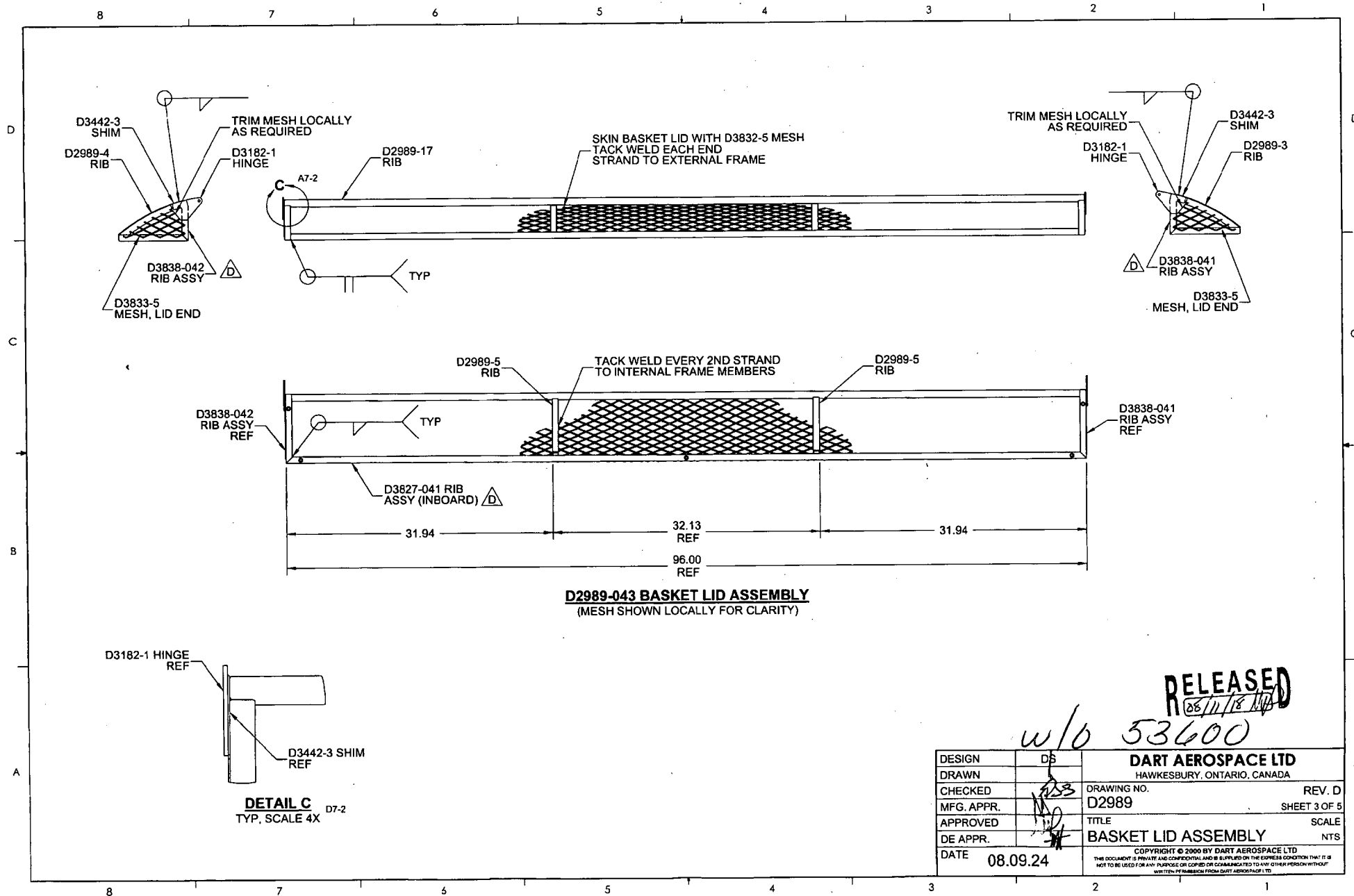
| D          | REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG); REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM | MB  | 08.09.24 |
|------------|--|-----|----------|
| C          | FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD  | AJS | 08.06.20 |
| B          | ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS   | PH  | 05.06.07 |
| A          | NEW ISSUE  | DS  | 00.10.27 |
| REV.       | DESCRIPTION  | BY  | DATE     |
| DESIGN     | DS   |     |          |
| DRAWN      | AS   |     |          |
| CHECKED    | AS   |     |          |
| MFG. APPR. | AS   |     |          |
| APPROVED   | AS   |     |          |
| DE APPR.   | AS   |     |          |
| DATE       | 08.09.24   |     |          |

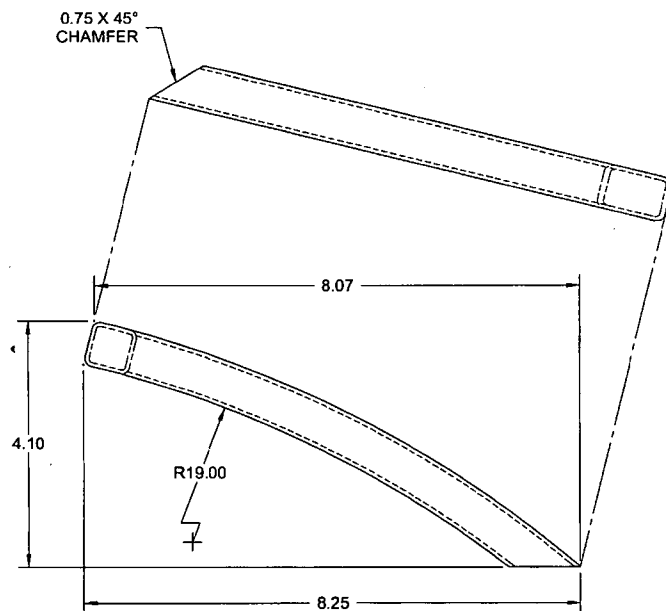
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2989** REV. D  
SHEET 1 OF 5  
TITLE **BASKET LID ASSEMBLY** SCALE NTS

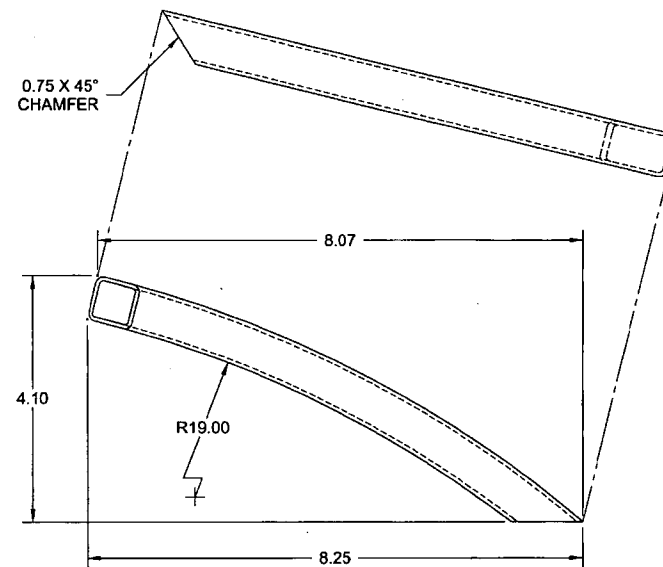
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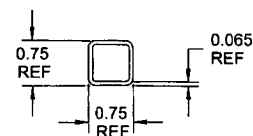




**D2989-3 RIB**



**D2989-4 RIB**



**TYPICAL SECTION VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

**RELEASED**  
08/11/18/11/10

*w/o* 53600

|            |          |  |        |
|------------|----------|--|--------|
| DESIGN     | DS       | <b>DART AEROSPACE LTD</b>  |        |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |        |
| CHECKED    |          | DRAWING NO. <b>D2989</b>   | REV. D |
| MFG. APPR. |          | SHEET 4 OF 5   |        |
| APPROVED   |          | TITLE  | SCALE  |
| DE APPR.   |          | <b>BASKET LID ASSEMBLY</b>   | NTS    |
| DATE       | 08.09.24 | <small>COPYRIGHT © 2000 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |        |

